

Work Order ID 166533

Wednesday, September 27, 2017 9:09:24 AM

166533

Page 1

Item ID: D3574-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 9/27/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/27/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: SEP 27 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								
100	FLOW WATER JET	0.00							DAS 40 9-89
100									
Waterjet	Memo	0.31							
FLOW CNC Waterjet	1-Cut as per Dwg D3574 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 40 9-89
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.02							
Quality Control									

SEP 27 2017

Work Order ID 166533***166533***

Page 2

Wednesday, September 27, 2017 9:09:24 AM

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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

N1A

DAS
38
9-89

0.00

0.17

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

N1A

DAS
38
9-89

0.00

0.02

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

PPP166520

0.00

0.01

DAS
28
9-89

SEP 27 2017

Work Order ID 166533***166533***

Page 3

Wednesday, September 27, 2017 9:09:24 AM

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Required Date: 9/27/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

SEP 27 2017

DAS
21
9-89

Picklist Print

Wednesday, September 27, 2017 9:09:27 AM

Page 1

Work Order ID: 166533

166533

Parent Item: D3574-5

D3574-5

Parent Item Name: Cabin Floor Protector

Start Date: 9/27/2017

Required Date: 9/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

100

sf

6,808.380

21.55

25.35294

MI FXS 125-F60029-04

**

17/09/27

DAS
40
9-89

GE PLASTICS LEXAN SHEET (DARK GREY)

Location

Loc Qty

Loc Code

mat

749.94

m137737

749.94

26

MAT018

6058.44

m137737

2218.44

m138511

3840

DART AEROSPACE LTD		Work Order:	166533
Description: Cabin Floor Protector		Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø3.001	1			
7.37	+/-0.030	7.375	1			
11.00	+/-0.030	11.00	1			
15.25	+/-0.030	15.255	1			
25.87	+/-0.030	25.88	1			
39.75	+/-0.030	39.74	1			
44.75	+/-0.030	44.75	1			
49.11	+/-0.030	49.10	1			
51.11	+/-0.030	51.10	1			
1.75	+/-0.030	1.75	1			
58.38	+/-0.030	58.39	1			
63.50	+/-0.030	63.50	1			
65.25	+/-0.030	65.25	1			
11.87	+/-0.030	11.88	1			
14.75	+/-0.030	14.754	1			
26.00	+/-0.030	26.00	1			
40.87	+/-0.030	40.88	1			
45.00	+/-0.030	45.00	1			
48.00	+/-0.030	48.00	1			
55.13	+/-0.030	55.14	1			
58.38	+/-0.030	58.39	1			
61.25	+/-0.030	61.255	1			
61.88	+/-0.030	61.89	1			
64.63	+/-0.030	64.64	1			
7.63	+/-0.030	7.64	1			
11.00	+/-0.030	11.00	1			
22.50	+/-0.030	22.50	1			
35.13	+/-0.030	35.14	1			
36.50	+/-0.030	36.50	1			
40.00	+/-0.030	40.00	1			
41.88	+/-0.030	41.89	1			
43.63	+/-0.030	43.64	1			
6.75	+/-0.030	6.75	1			

DART AEROSPACE LTD		Work Order: 166533
Description: Cabin Floor Protector		Part Number: D3574-5
Inspection Dwg: D3574 Rev: B		Page 2 of 2

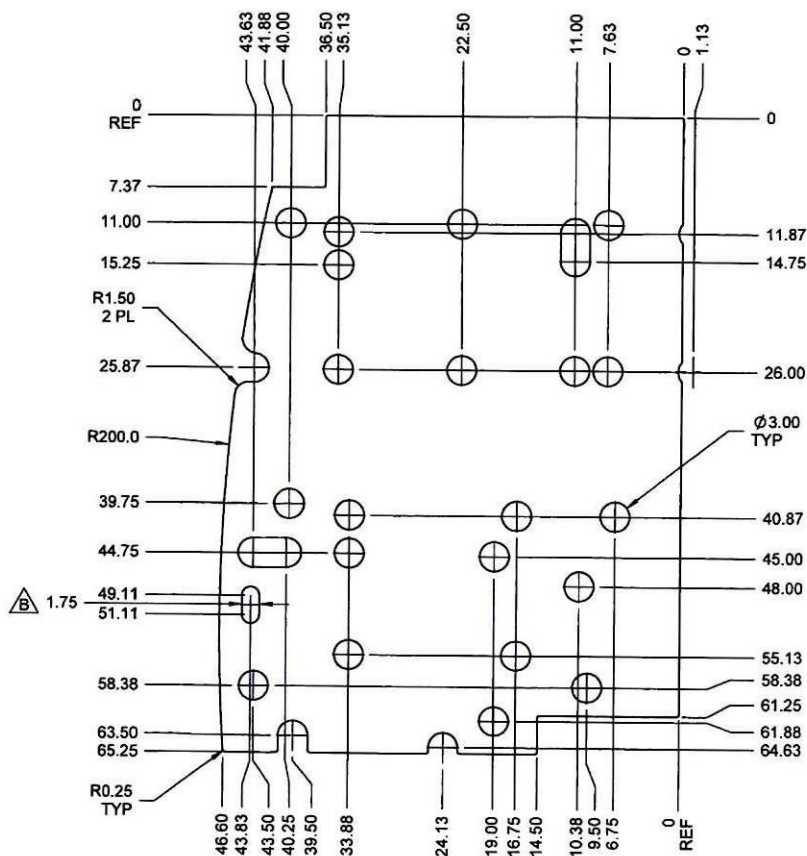
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.50	1		VDC-03	
10.38	+/-0.030	10.39	1		T9.80	
14.50	+/-0.030	14.50	1			
16.75	+/-0.030	16.755	1			
19.00	+/-0.030	19.00	1			
24.13	+/-0.030	24.14	1			
33.88	+/-0.030	33.87	1			
39.50	+/-0.030	39.50	1			
40.25	+/-0.030	40.25	1			
43.50	+/-0.030	43.50	1			
43.83	+/-0.030	43.84	1			
46.60	+/-0.030	46.60	1			
0.125	+/-0.010	0.125	1			

Measured by: DAS 40	Audited by: DAS 38	Prototype Approval:	N/A
Date: 17/09/21 9-89	Date: SEP 27 2017 9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	HA



D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160533 M5
1-09-27

RELEASED
07/04/07 JMB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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